

Work Order ID 79181

79181

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January-23-12 10:46:41 AM

Item ID: D2804-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket Assembly
 Start Date: 23/01/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 06/02/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/01/23 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2804	Rev C								

100
100
 Small Fab
 Small Fab
 Small Fab

Small Fab
 Memo
 Press D2805-1 Into arm as per Dwg D2804

0.00
 0.00

[Handwritten signature] 12/02/02 (6)

110
110
 QC
 Quality Control

QC5- Inspect part completeness to step on W/O
 Memo
 Quality Control

0.00
 0.00

S 12/02/02

(X6)

041

120
120
 Powdercoat
 Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum
 Memo
 START TIME: 8:20 OVEN TEMPERATURE:
 FINISH TIME: 8:50

0.00
 0.00

6X0 M/L 12/02/03

M 119480

320015

8:50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 23/01/2012 **Start Qty:** 6.00 ***6***

Cust Item ID:

Required Date: 06/02/2012 **Req'd Qty:** 6.00 ***6***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

**Insp.
Stamp**

0.00

130

QC

Memo

0.00

Quality Control

0.00

140

Small Fab

Small Fab

Small Fab

Memo

0.00

Press D2809 into arm as per Dwg D2804

0.00

150

Small Fab

Small Fab

Small Fab

Memo

0.00

1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804 2-Assemble as per Dwg D2804.

6 ~~14~~ 17-2-30

Ep 12/02/10 @

25/02/10 (6)

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00							
Quality Control									

SB 12/02/10

170	Identify as per dwg & Stock Location: <u>ST 148</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									

12/02/13

180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

M.L.J 12/02/14

12/02/14
16

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 79181

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Parent Item: D2804-041

D2804-041

Parent Item Name: Bracket Assembly

Start Date: 23/01/2012

Required Date: 06/02/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP F05.03.30MS21043-3 was MS21042L3KJ/JLM
IPP Rev:G As per Rev C 06-11-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2804-1		Manufactured	No			100	Each	0.0000	1	6			
D2804-1													
Bracket													
D2805-1		Manufactured	No			100	Each	18.0000	1	6			
D2805-1													
Stop													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				GA			18						
				75242			8						
				76185			10						
NAS1515H3		Purchased	No			100	Each	147.0000	4	24			
NAS1515H3													
Washer													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				ST277			147						
				116373			2						
				118078			6						
				118384			11						
				119438			28						
				120142			100						

M120518
(24x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D2804-041

D2804-041

Parent Item Name: Bracket Assembly

Start Date: 23/01/2012

Required Date: 06/02/2012

Start Qty: 6.00

Required Qty: 6.00

AN3C16A

Purchased

No

150

Each

60.0000

2

12

AN3C16A

Bolt

**

EB 12/02/10

Location

Loc Qty

Loc Code

ST352

60

115835

1

118422

4

118628

13

119641

42

D2809

Manufactured

No

150

Each

29.0000

1

6

D2809

Bushing

**

EB 12/02/10

Location

Loc Qty

Loc Code

GA

7

72735

7

ST018

22

34035

12

77292

10

MS21043-3

Purchased

No

150

Each

1,193.000

2

12

MS21043-3

Nut

**

EB 12/02/10

B 79689
(62)

Location

Loc Qty

Loc Code

FG

72

103691

72

ST300

582

119901

582

ST301

539

118077

2

118614

441

118686

30

119758

66

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Shop Packet Print

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

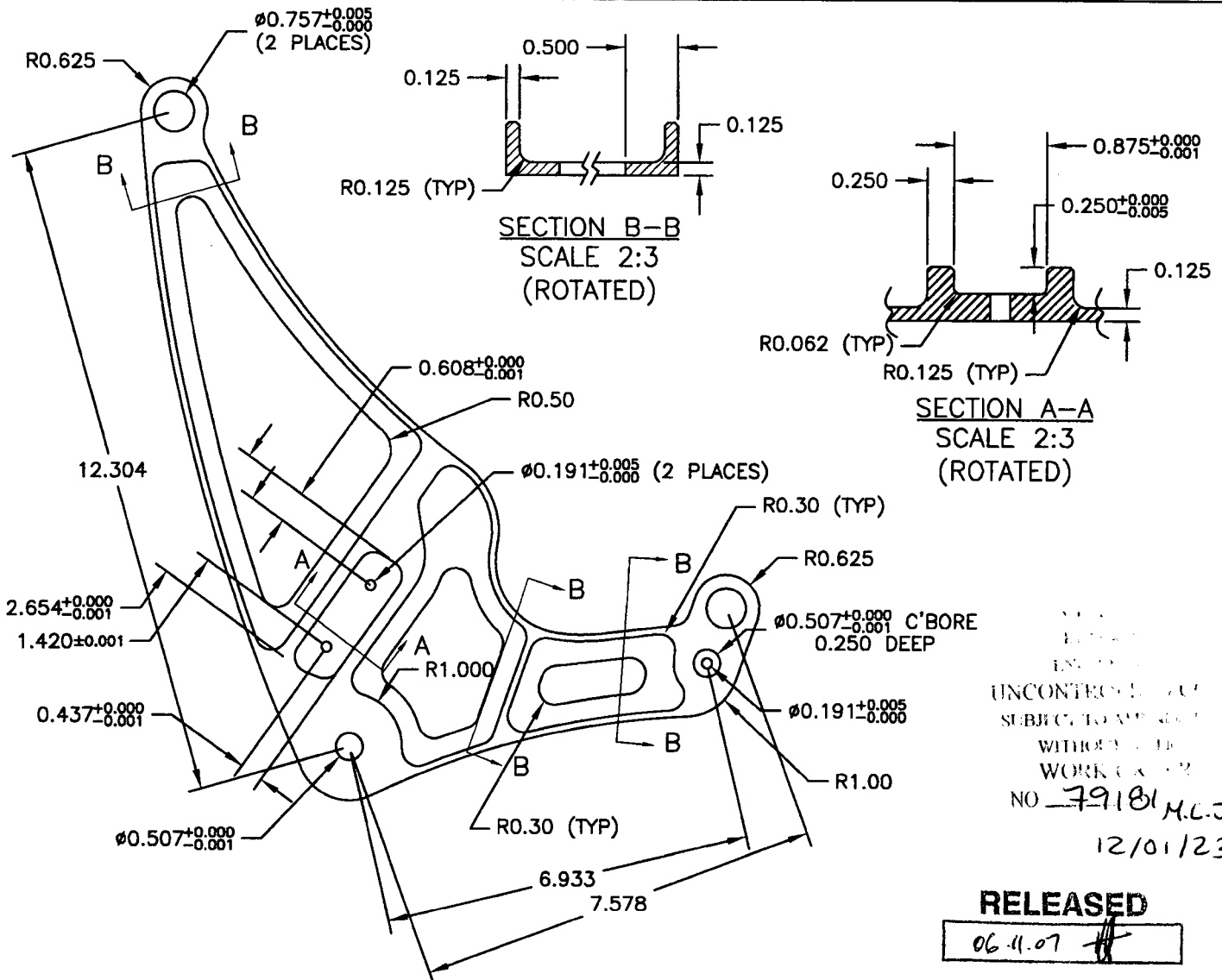
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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2804	REV. C SHEET 1 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	
C	06.10.16	CHANGE GEOM. TO ADD CLEARANCE	

**D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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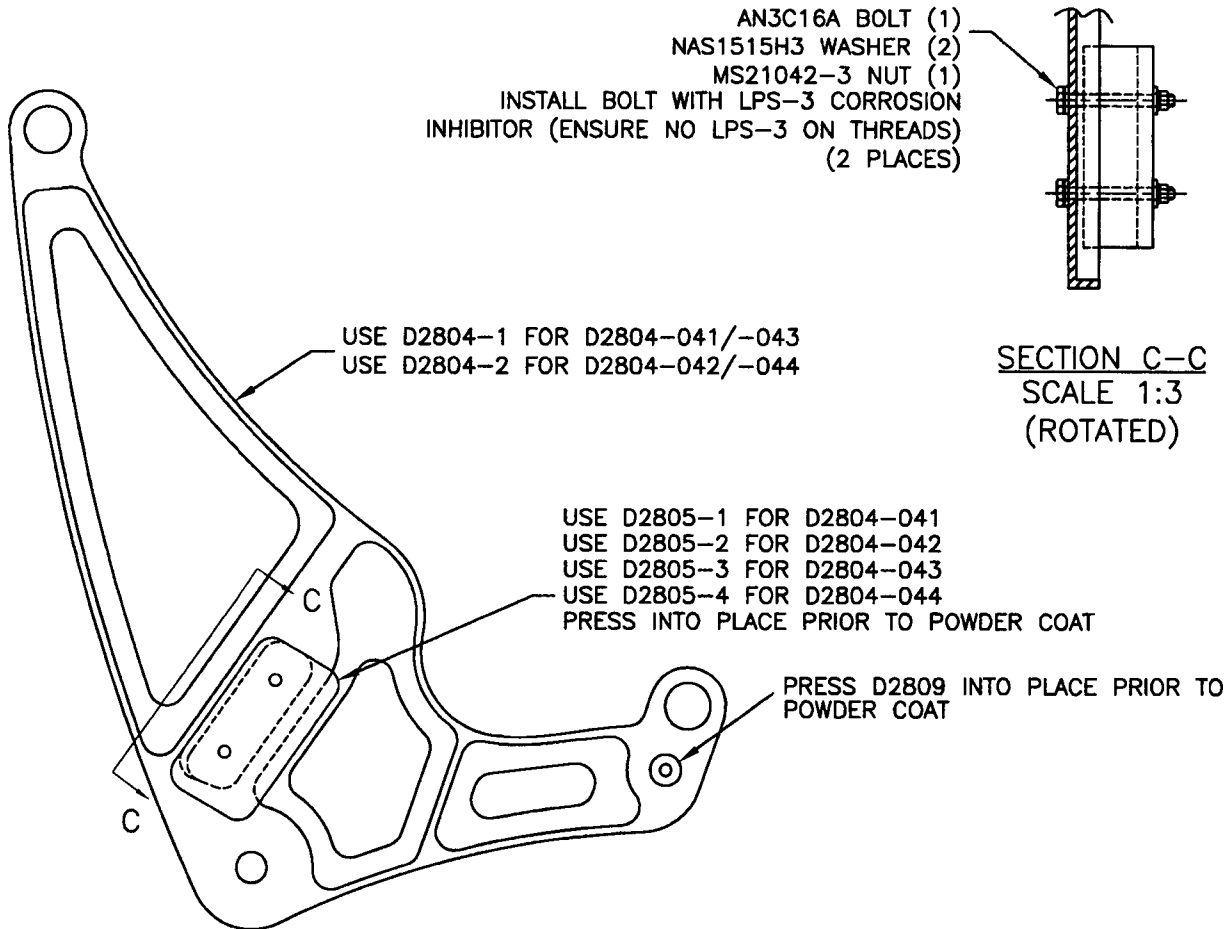
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DART

79181

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3



RELEASED

06.11.07 *[Signature]*

D2804-041/-043 BRACKET ASS'Y (SHOWN)

D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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